

9

Date: Monday, 1/7/2008 4:27:40 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 36652C		
Estimate Number	: 12353		
P.O. Number	:	Part Number	: D41269403
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: D412-694
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C1
Previous Run	: 27340C	Material	:
Written By	:	Due Date	: 2/28/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>108.01.8</u>		
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF		
	: Est Rev: B 06.04.18 New dwg rev. ecn781 EC		
	: Est Rev: C 06.07.11 Revised per B24660 KJ		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-03. CHG005

2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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Comment: COMPOSITE ASSEMBLY

D412-694-03 Drill Process

1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference. ✓

2- Drill Pilot holes Ø(#30) using drill Jig D3120-3T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3. ✓

3- Drill Pilot holes Ø(#30) using drill Jig DT8703-4 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM). ✓

4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-5. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF). ✓

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-6. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF). ✓

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom. ✓

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA). ✓

ml 08/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

M19443
M107007
31 Jan. 2009

ml 08/02/07

4.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

ml 08/02/07

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

16-02-07

6.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045 Primer Filler

Batch: 106 803

A/R 12375S Reducer

Batch: 106 803

RT 08-02-08

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12-02-08

8.0

D31101

~~Handle~~



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Escutcheon

Batch

B 31757

ml

9.0

D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B27539

ml

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3111041

Plate Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Plate Assembly
Batch M10536-17

ml

11.0

D311121

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Guide
Batch B35122

ml

12.0

D311131

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spring
Batch B27366

ml

13.0

D311141

Pivot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pivot
Batch B18630

ml

14.0

D311165

Seal 110-031-4



Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s)
Seal 110-031-4
Batch B27208

ml

15.0

D311161

SEAL



Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)
SEAL
Batch B27241

ml

16.0

D3119041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cover Assembly
Batch B27724

ml

ml 08/02/07

W/O:		WORK ORDER CHANGES					
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Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D31201

Cover, Flat Pattern



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cover, Flat Pattern
Batch M10536-17

ml

18.0

D31203

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cover
Batch B18658A M10536-17

mini 2008/1/15

ml

19.0

D31251

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
D3125-1 Lever
Batch M10536-17

ml

20.0

D31253

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lever
Batch M10536-17

ml

21.0

D31255

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lever
Batch M10536-17

ml

22.0

D31257

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lever
Batch M10536-17

ml

23.0

D31291

Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Lever
Batch M10536-17

ml 08/01/17

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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D31301

Clevis Base



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Clevis Base
Batch M10536-17

ml

25.0

D31311

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Stop
Batch M10536-17

ml

26.0

D31341

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rod
Batch B27338

ml

27.0

D31343

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
D3125-3 Rod
Batch B21381

ml

28.0

D314007

Door Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Door Kit
Batch B36652C M106688 mi-2008/2/15

ml

29.0

D31431

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Clevis
Batch M10536-17

ml

30.0

D31433

Clevis



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Clevis
Batch M10536-17

ml

ml 08/02/07

W/O:		WORK ORDER CHANGES					
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Job Number: 36652C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D31441

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Doubler
Batch B18816

ml

32.0

D3144105

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Doubler
Batch B23143

ml

33.0

D3144107

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Doubler
Batch B23144

ml

34.0

D31451

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket
Batch B26502

ml

35.0

D31461

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
Batch B26709

ml

36.0

D31471

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pin
Batch 30824

ml

37.0

D31491

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Striker Plate
Batch M10536-17

ml 08/01/19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: DOOR ASSEMBLY

Job Number: 36652C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

D31501

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Guide
Batch M10536-17

ml

39.0

D31541

Key



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Key
Batch M10536-17

ml

40.0

D31571

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spacer
Batch M10536-17

ml

41.0

D3159041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Bracket Assembly
Batch B18641

ml

42.0

D3159043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch ~~B24707~~ B24859

ml

43.0

AN52510R7

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
Batch M106166

ml

44.0

AN960JD6L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Batch M5519

ml 08/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M106112

ml

46.0

AN960JD8L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M6956

ml

47.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch

106167

ml

48.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

Batch

104374

ml

49.0

AN960JD10LL

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

Batch

M19600

ml

50.0

ALS463280

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert

Batch

M17841

ml

51.0

BSP45

Commercial Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Commercial Rivet

Batch

11821

(x14)

20x M106937

ml 08/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

BSP46

Commercial rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Commercial rivet

Batch M 101237

ml

53.0

FW4032

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch M 101203

ml

54.0

FW10032

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch M 19249

ml

55.0

M7885344

Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivets

Batch M 19099

ml

56.0

M7885345

Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rivet

Batch M 1108

ml

57.0

MS203921C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch M 18822

ml

58.0

MS203922C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch M 14149

ml 08/01/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 36652C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
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59.0	MS203922C15	Pin
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

M101340

ml

60.0	MS21042L3	Nut
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

M105558

ml

61.0	MS21042L06	Nut
------	------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M106612

ml

62.0	MS24665151	Cotter Pin
------	------------	------------



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

M14526

ml

63.0	MS24694C4	SCREW
------	-----------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

15924

ml

64.0	MS24694S53	SCREW
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15798

ml

65.0	MS24694S56	SCREW
------	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

M104407

ml

08/01/17

Dart Aerospace Ltd

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Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

66.0

MS24694S60

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M11766 ~~6011706?~~

ml

67.0

MS25281R6

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Batch

M19098

ml

68.0

MS27039106

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

M106815

ml

69.0

MS27039108

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

M105076

ml

70.0

MS35206231

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M11735

ml

71.0

MS35650305T

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M11786

ml

72.0

MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

M11822

ml 08/01/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

73.0

NAS116910L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

m 11753

ml

74.0

NAS38868P

Screw



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Screw

Batch

m 19098

ml

75.0

NAS391B6P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

m 19098

ml

76.0

NAS43DD340

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

m 11737

ml 08/01/17

77.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-03 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB). Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x 100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg

ml 08/02/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 4:27:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

D412-694 page 5 (view W).

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket: Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

9- Install (1) D3159-043 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.
Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.
Note: Position strike plate when big door is in locked position.

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3.

A/R RTV732 Clear Batch: M 105700 Expiry Date: 23 July 2009

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-041 cover using drilling Jig D3119-041T1/T2 as per Dwg D412-694 page 3. Trim D3119-041 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

m 10/08/02/12

78.0

QC5

INSPECT WORK TO CURRENT STEP



PTO


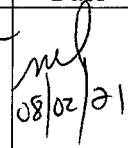
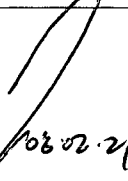
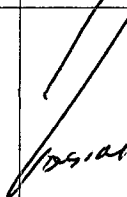
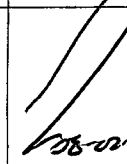
Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/21	78	Scrap one D3150 1 When install door on make up for test		Destroy it and replace by new one D3150- 1 M 10536-17 guide				

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 4:27:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

79.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

(Put red label inside before putting the cover D3119-041/or Vip trim)

ml 08/02/21
1- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly. *ml 08/02/21*

80.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

81.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 208/02/26

①

82.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/02/26

Job Completion



mi 2008/2/26

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
05.12.01

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D012-004-01	DOOR ASSEMBLY
	X			D012-004-02	DOOR ASSEMBLY
		X		D012-004-03	DOOR ASSEMBLY
			X	D012-004-04	DOOR ASSEMBLY
		1	1	D0110-1	ESCUTCHEON
		1	1	D0110-3	HANDLE
		1	1	D0110-6	HANDLE ASSEMBLY
1	1			D0111-041	PLATE ASSEMBLY
		2	2	D0112-1	GUIDE
		1	1	D0113-1	SPRING
		1	1	D0114-1	PIVOT
1	1			D0115-1	BRACKET
		1	1	D0116-11-0180	SEAL
		1	1	D0116-5-080	SEAL
1	1			D0116-7-080	SEAL
1	1			D0116-9-070	SEAL
		1		D0119-041	COVER ASSEMBLY
		1		D0119-042	COVER ASSEMBLY
		1		D0120-1	COVER
		1		D0120-2	COVER
		1		D0120-3	COVER
		1		D0120-4	COVER
3	3			D0121-041	BRACKET ASSEMBLY (ROLLER)
1				D0121-043	BRACKET ASSEMBLY (ROLLER)
		1		D0121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D0122-1	LEVER
2	2			D0123-1	CAM
1	1			D0124-1	HOOK
1	1			D0124-2	HOOK
		1	1	D0125-1	LEVER
		1	1	D0125-3	LEVER
		1	1	D0125-5	LEVER
		1	1	D0125-7	LEVER
1	1			D0126-1	BRACKET (SLIDER)
1	1			D0126-3	BRACKET (SLIDER)
5	5			D0126-5	BRACKET (SLIDER)
1	1			D0127-1	SPACER
		1	1	D0128-1	SHIM
		2	2	D0129-1	LEVER
		2	2	D0130-1	CLEVIS BASE
		1	1	D0131-1	STOP
1				D0132-041	ROD WELDMENT
	1			D0132-042	ROD WELDMENT
	1			D0133-041	ROD WELDMENT
1				D0133-042	ROD WELDMENT
		1	1	D0134-1	ROD
		1	1	D0134-3	ROD
1	1			D0135-041	HANDLE WELDMENT
1	1			D0137-046	BRACKET ASSEMBLY
		1		D0138-1	COVER
		1		D0138-2	COVER
1	1			D0139-1	GUARD
1	1			D0139-3	GUARD
1	1			D0139-4	GUARD
		1		D0140-06	DOOR
		1		D0140-06	DOOR
1				D0140-07	DOOR
		1		D0140-08	DOOR
		1	1	D0141-1	SPRING
		1	1	D0143-1	CLEVIS
		3	3	D0143-3	CLEVIS
		1		D0144-1	DOUBLER
		1		D0144-3	DOUBLER
		1		D0144-105	DOUBLER
		1		D0144-107	DOUBLER
1				D0144-108	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D0144-111	DOUBLER
	1			D0144-115	DOUBLER
		1		D0144-117	DOUBLER
		1		D0144-121	DOUBLER
		1		D0144-119	DOUBLER
1	1			D0144-123	DOUBLER
1	1			D0144-13	DOUBLER
		1		D0145-1	HINGE BRACKET
		1		D0145-2	HINGE BRACKET
		1		D0145-1	HINGE BRACKET
		1		D0145-2	HINGE BRACKET
		2	2	D0147-1	PIN
2	2			D0148-1	CLEVIS
		2	2	D0149-1	STRIKER PLATE
		2	2	D0150-1	GUIDE
1	1			D0151-041	DOUBLER ASSEMBLY
1				D0152-041	BRACKET ASSEMBLY
	1			D0152-042	BRACKET ASSEMBLY
		1	1	D0154-1	KEY
1	1			D0155-041	BRACKET ASSEMBLY
1	1			D0155-042	BRACKET ASSEMBLY
2	2			D0156-1	BRACKET
		2	2	D0157-1	SPACER
		3	3	D0158-041	BRACKET ASSEMBLY
		1		D0158-043	BRACKET ASSEMBLY
		1		D0158-044	BRACKET ASSEMBLY
10	10			D0162-041	BRACKET ASSEMBLY
1		1		D0162-043	BRACKET ASSEMBLY
1		1		D0162-044	BRACKET ASSEMBLY
1				D0163-041	COVER ASSEMBLY
1				D0163-042	COVER ASSEMBLY
1				D0163-041	BRACKET ASSEMBLY (ROLLER)
1				D0163-042	BRACKET ASSEMBLY (ROLLER)
1	1			D0203-1	HANDLE ASSEMBLY
2	2			D0308-1	DOUBLER
55	55	21	21	80-005-28	INSERT (OR SL2052-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN650D10	WASHER
18	18	4	4	AN650D10L	WASHER
13	13	32	32	AN650D10LL	WASHER
6	6			AN650D14L	WASHER
		4	4	AN650D16L	WASHER
6	6			AN650D18	WASHER
		2	2	AN650D18L	WASHER
		2	2	AN650D18LL	WASHER
		10	10	ASL4632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	PW10-032	WASHER
		6	6	PW4-032	WASHER
12	12			M7885-24	RIVET (OR CR3213-4-3)
		3	3	M7885-34	RIVET (OR CR3212-4-3)
		2	2	MS2092-1C11	PIN
		7	7	MS2092-2C15	PIN
2	2			MS2092-2C17	PIN
2	2	2	2	MS2092-3C9	PIN
2	2			MS2092-3C21	PIN
8	8			MS20425A05	RIVET
12	12			M7885/3-4	Rivet
8	8			MS20426A04	Rivet

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20425A04	RIVET
		6	6	MS21042L06	NUT
6	6	2	2	MS21042L08	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUT PLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24665-S271	SCREW
		2	2	MS24664-04	SCREW
4	4			MS24664-05	SCREW
6	6			MS24664-S5	SCREW
18	18			MS24664-S50	SCREW
		4	4	MS24664-S56	SCREW
		2	2	MS24664-S53	SCREW
4	4			MS24664-S50	SCREW
		2	2	MS24664-S56	SCREW
2	2	2	2	MS2261-F6	CLAMP
14	14	12	12	MS27039-1-05	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35203-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS35649-254	NUT
		4	4	MS35650-305T	NUT
2	2			MS35650-3252	NUT
2	2	3	3	MS1859-7	WASHER
		4	4	NAS1169-10L	WASHER
		14	14	NAS388-6-SP	SCREW
		15	15	NAS381BSP	WASHER
7	7			NAS300D-10	SPACER
6	6			NAS300D-14	SPACER
		2	2	NAS300D-40	SPACER

GENERAL NOTES

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D0124-1/2 HOOK RESTS AGAINST CUTOFF SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D0125-1 LEVER (REF) TO CLEAR THE D0130-1 CLEVIS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS. B30-23000-01; D0144-T4-T2-T3; D18703-3; D0162-041T1 (FOR -01 DOOR ASSY); B30-23000-02; D0144-T7-T8-T9; D18703-9; D0162-041T2 (FOR -02 DOOR ASSY); D0144-T4-T5-T6; D0119-041T1; D0112-T4-T2 (FOR -03 DOOR ASSY); D0144-T10-T11-T12; D0119-042T1; D0112-T4-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER PART Q5 006. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER PART Q5 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D012-004-01-02-03-04 DOOR ASSEMBLIES USING D0729-1 DECALS.

C1	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	DRAWING NO. D412-694
		TITLE DOOR ASSEMBLY
		REV. C SHEET 1 OF 6 SCALE NTS

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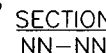


D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)

VIEW LOOKING @ INSIDE OF DOOR



(D3138-1/-2 SHOWN IN SECTIONS
FOR CLARITY OF HDWR LOCATIONS)






D3144-13 DOUBLER (1)
BSP45 RIVETS (39 PLACES)
TRANSFER DRILL #30 FROM
DOUBLER TO DOOR
APPLY 732 RTV CLEAR (A/
RIVET HOLE PRIOR TO INSTA
AND RIVET HEAD AFTER INS

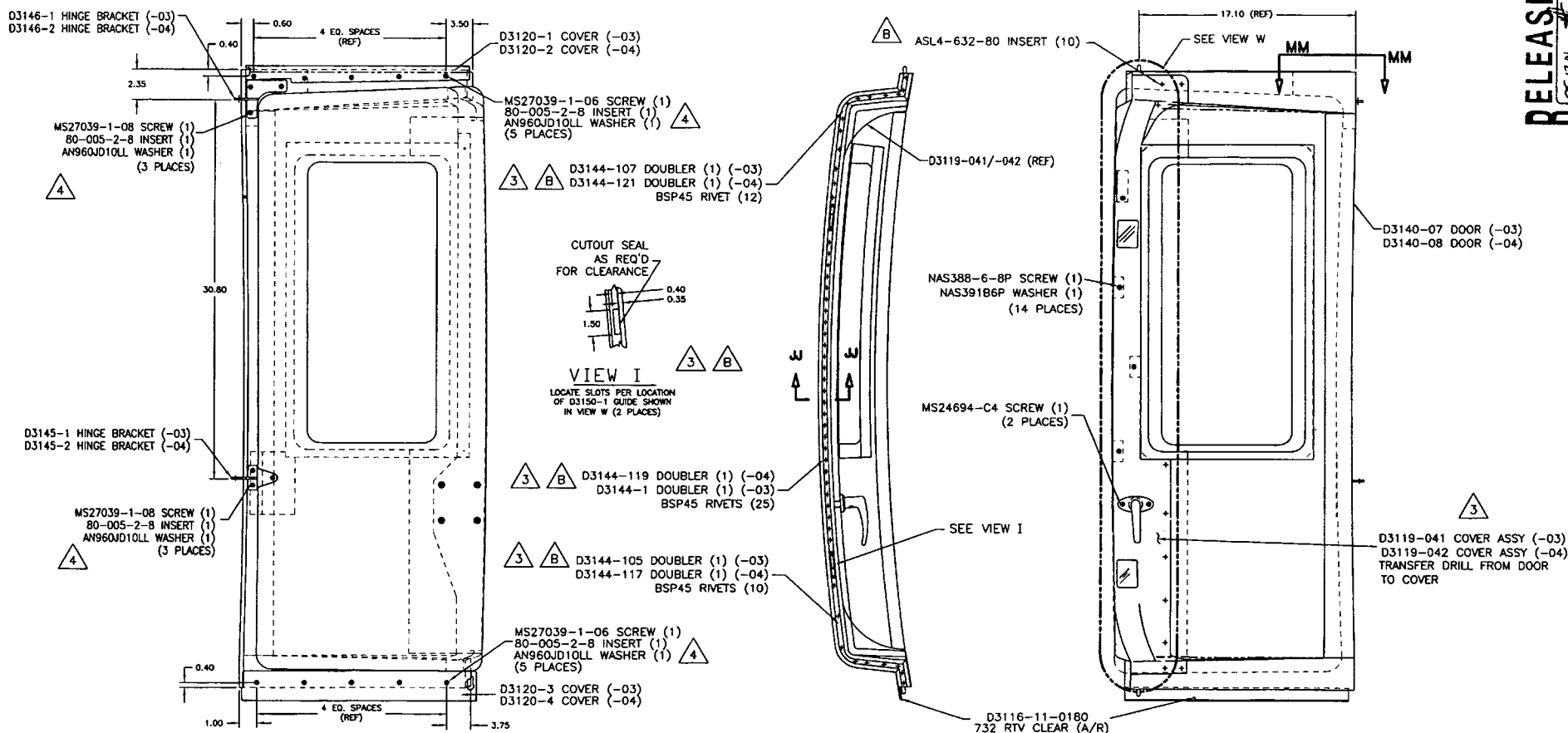


OF 03155-041/-042 BRKT SHOWN
IN VIEW P (2 PLACES)

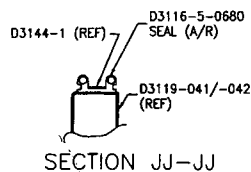


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	CP	RF		
	CHECKED 	APPROVED 	DRAWING NO. D412-694	REV. C SHEET 2 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY		SCALE N.T.S.	

RELEASED



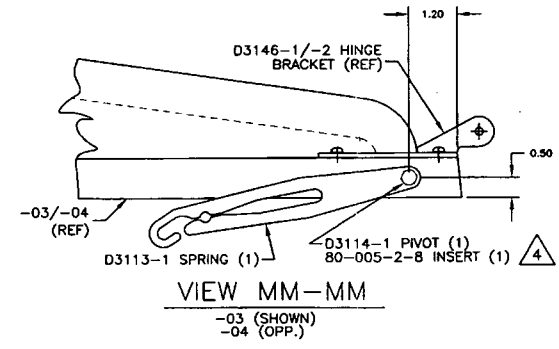
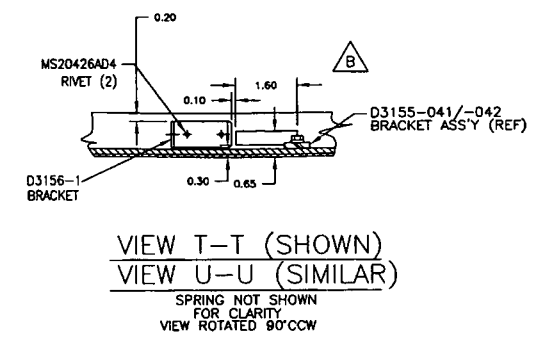
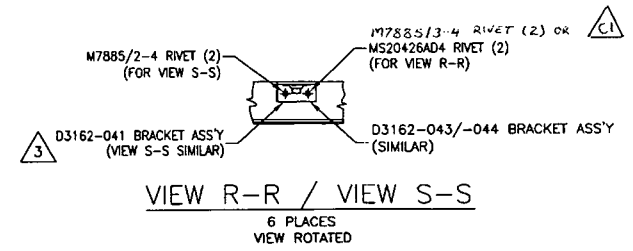
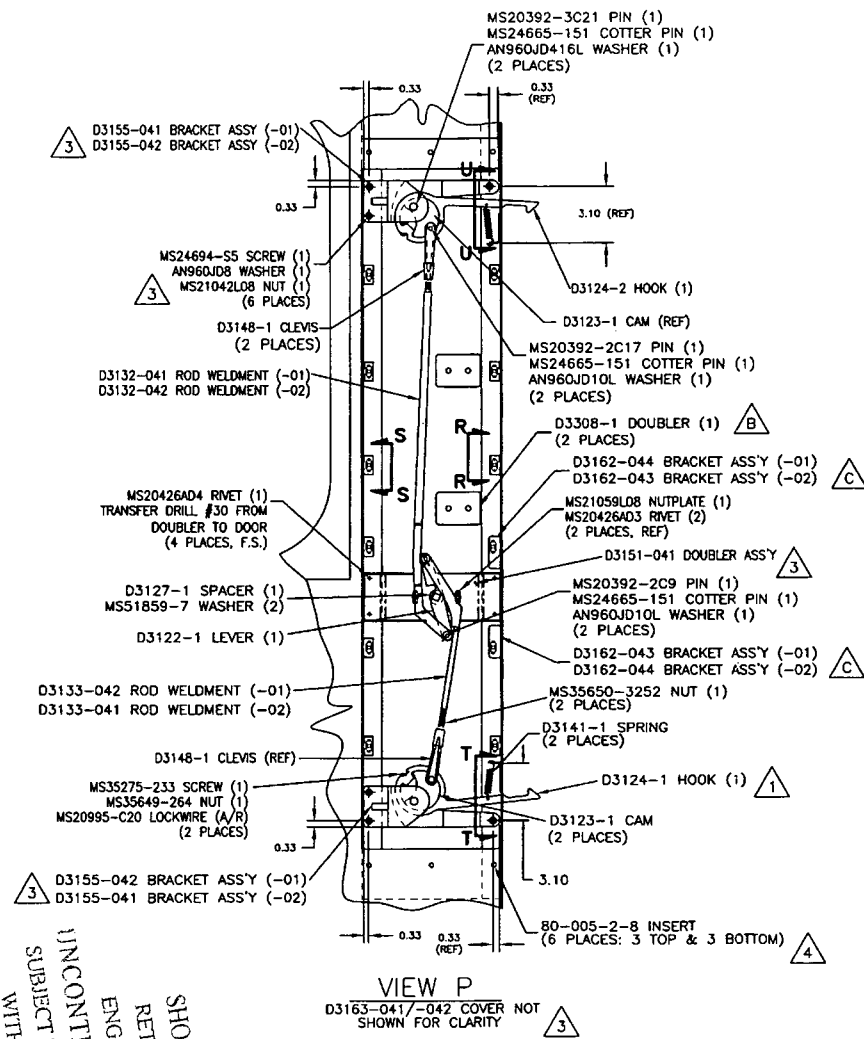
D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)



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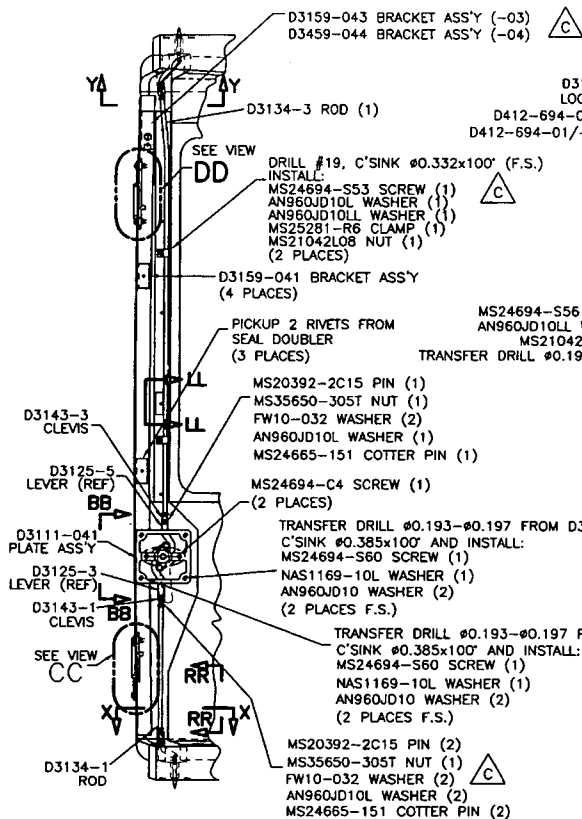
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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	

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05/12/01



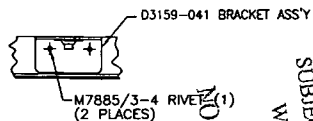
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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	



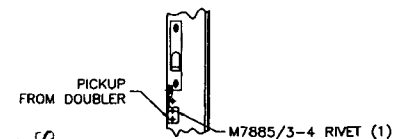
VIEW W

D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY
SEAL ALSO NOT SHOWN FOR CLARITY

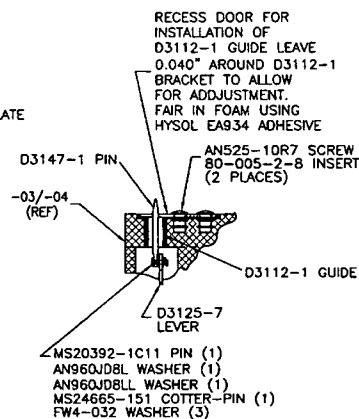
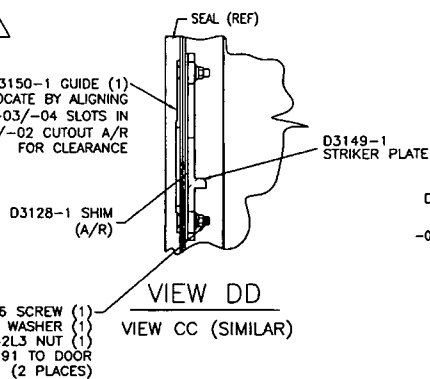


SECTION LL-LL
(3 PLACES)
VIEW ROTATED 90°CCW

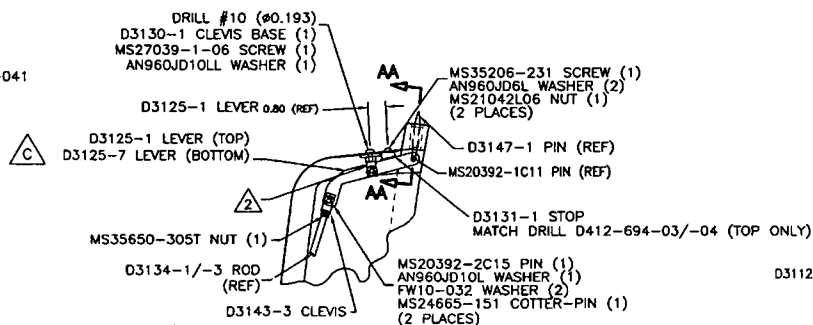
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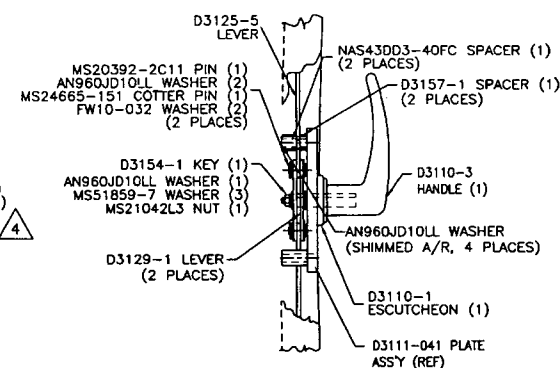
VIEW RR-RR



SECTION AA-AA

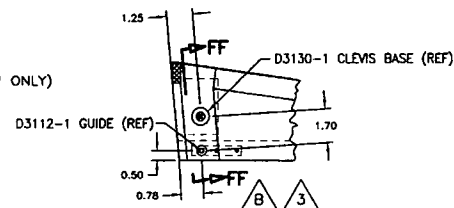


SECTION FF-FF



SECTION BB-BB

VIEW SHOWN WITH MECHANISM
IN THE UNLOCKED POSITION
FOR CLARITY



SECTION X-X (SHOWN)

SECTION Y-Y (SIMILAR)

D3125-1 LEVER NOT SHOWN FOR CLARITY

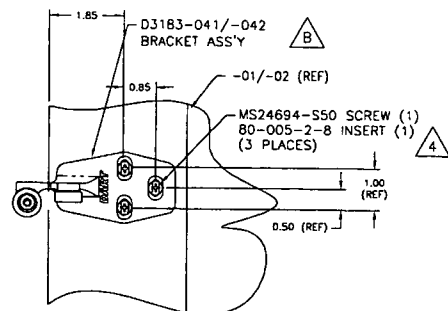
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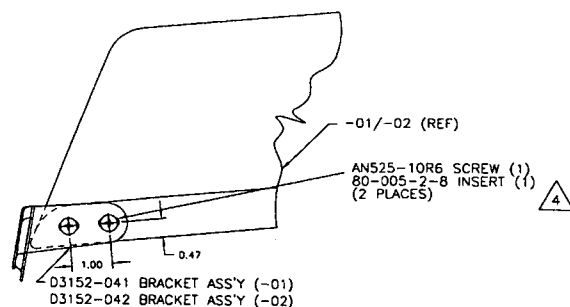
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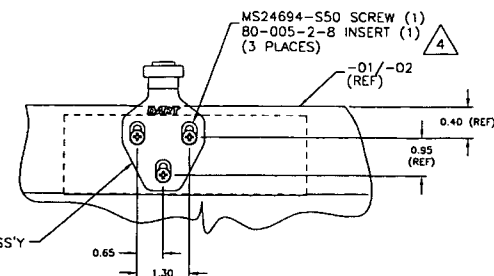
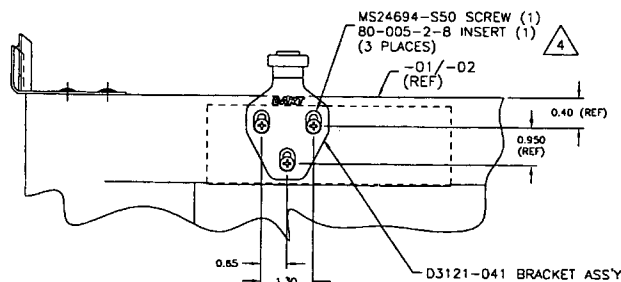
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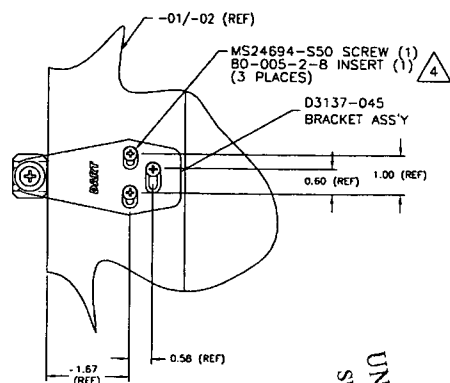
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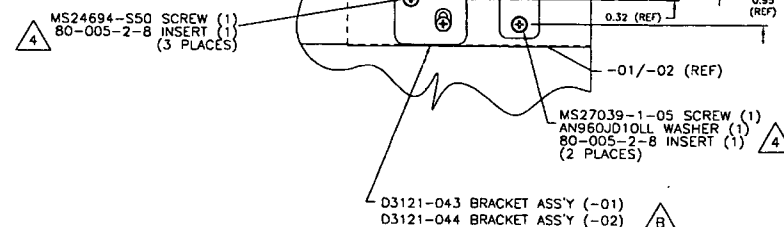
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